

duplicate

Date: Monday, 14/04/2008 9:05:17 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-UTILITY BASKET RH
Job Number : 38443	
Estimate Number : 13190	
P.O. Number :	Part Number : D205541046
This Issue : 14/04/2008 S.O. No. :	Drawing Number : IIN D205-541 P8-16
Prsht Rev. : NC	Project Number :
First Issue : 07/04/2008 Type : LARGE FAB ASSY	Drawing Revision : G
Previous Run : 38216	Material :
Written By :	Due Date : 28/04/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 08.4.14</u>	
Comment : Est Rev:A new issue 08-02-15 DD verified by: Est Rev:B Ecn 1157 08-03-19 DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: Photocopy bluefile & type labels per PPPD205-541-046 CHG001 <i>08/04/28 08/4/18</i>		
2.0	D3712042	LOW PROFLE BASKET BASE ASSEMBLY
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) LOW PROFLE BASKET BASE ASSEMBLY batch <u>38460</u> <i>ml 08/04/28</i>		
3.0	D3713042	LID ASSEMBLY
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) LID ASSEMBLY batch <u>B 38461</u> <i>ml 08/04/28</i>		
4.0	D2258300	Placard
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Placard Batch: <u>37538</u> <i>JP</i>		
5.0	D2332041	Lid Prop Assembly 6.69"
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Lid Prop Assembly 6.69" Batch: <u>36849</u> <i>PC 4/25 (1)</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch: 37546

Handwritten signature

7.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: 37071

Handwritten signature

8.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 36803

Handwritten signature

9.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M106815

Handwritten signature

10.0

AN420A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

batch M16898

Handwritten signature

11.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104937

Handwritten signature

12.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104547

Handwritten signature and circled '1'

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M107242

[Signature]

14.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch: M107321

[Signature]

15.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M107008

[Signature]

16.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch M107008

[Signature]

17.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M107242

[Signature]

18.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M106883

[Signature]

19.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nut

Batch: M106051

[Signature] 8/9/25 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M106785

[Signature]

21.0

D37231

BUSHING



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

FWD PLATE

batch 38229

[Signature] 8/4/25 ①

22.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

-Assemble as per IIN 205-541-046

[Signature] 8/4/25 ① P70

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

[Signature] 8/4/25 ①

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

25.0

D21991

Struts, 19"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Struts, 19"

Batch: 37742

[Signature]

26.0

D219923

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: 37849

[Signature] 8/4/25 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-541-046 PAR #: NA Fault Category: Prod / Rep ^{not a model} NCR: Yes No DQA: LD Date: 08/04/28
 QA: N/C Closed: LD Date: 08/04/28

NCR: <u>38443</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/04/28</u>	<u>22</u>	<u>Handle doesn't fit well. Hard to open</u>	<u>QSRN</u>	<u>File the Hook where took the screws on the base, as QC asked</u>	<u>08/04/28</u> <u>ml</u>	<u>08/04/28</u>	<u>QSRN</u>	<u>08/04/28</u>

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Job Number: 38443

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D219925

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: 37537

Handwritten signature

28.0

D2498

Mounting Bracket, 205 Basket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Bracket

Batch: 37542

Handwritten signature

29.0

D2499

Mounting Bracket, 205 Basket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Bracket

Batch: 37543

Handwritten signature

30.0

D2515

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 29138

Handwritten signature

31.0

D30521

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Lug

Batch: 28522

Handwritten signature

32.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M102140

Handwritten signature

33.0

AN412A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: M105143

Handwritten signature and date: 8/4/25 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 38443

Part Number: D205541046

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	AN413A	Bolt
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Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

Batch: M107321

35.0	AN414A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M105653

36.0	AN57A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M1067F5

37.0	AN513A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104936

38.0	AN960JD416	Washer
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Comment: Qty.: 27.0000 Each(s)/Unit Total : 27.0000 Each(s)

Washer

Batch: M107321

39.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch: M107008

40.0	MS21042L4	Nut
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Batch: M106051

PC 8/4/20 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 38443

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: *M106285*

R 8/4/2008 (1)

42.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

55/04/28 AC

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-541-046

Location:

PPP Rev: *Draft*

R 8/4/28 (1)

44.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/28

Job Completion



W 08-04-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST HELI-UTILITY-BASKET™

Qty -043	Qty -044	Qty -045	Qty -046	Part Number	Description
X				D205-541-043	HELI-UTILITY-BASKET, LH
	X			D205-541-044	HELI-UTILITY-BASKET, RH
		X		D205-541-045	HELI-UTILITY-BASKET, LH
			X	D205-541-046	HELI-UTILITY-BASKET, RH
2*	2*			D2022-101	SPACER
1	1	1	1	D2199-1	STRUT
1	1	1	1	D2199-23	STRUT
1	1	1	1	D2199-25	STRUT
1*	1*	1*	1*	D2258-300	LABEL
1*	1*	1*	1*	D2332-041	PROP ASSEMBLY
1	1	1	1	D2498	MOUNTING LUG
1	1	1	1	D2499	MOUNTING LUG
1*	1*			D2512	BASKET LID ASSEMBLY
2	2	2	2	D2515	BUSHING
1*	1*	1*	1*	D2530	HANDLE ASSEMBLY
2*	2*	2*	2*	D2535	SPRING
2*	2*	2*	2*	D2537	BUSHING
2*	2*			D2931	BUMPER
1	1	1	1	D3052-1	MOUNTING LUG
1*				D3053-041	BASKET BASE ASSEMBLY, LH
	1*			D3053-042	BASKET BASE ASSEMBLY, RH
		1*		D3712-041	BASKET BASE
			1*	D3712-042	BASKET BASE
		1*		D3713-041	LID ASSEMBLY
			1*	D3713-042	LID ASSEMBLY
		6*	6*	D3723-1	BUSHING
2*	2*	2*	2*	AN3-16A	BOLT
2*	2*			AN4-7A	BOLT
2	2	2	2	AN4-7A	BOLT
3	3	3	3	AN4-12A	BOLT
9	9	9	9	AN4-13A	BOLT
2	2	2	2	AN4-14A	BOLT
		3*	3*	AN4-20A	BOLT
1*	1*	1*	1*	AN4-22A	BOLT
1*	1*	1*	1*	AN4-24A	BOLT
1	1	1	1	AN5-7A	BOLT
1	1	1	1	AN5-13A	BOLT
4*	4*	4*	4*	AN5-17A	BOLT
2*	2*	6*	6*	AN960JD416	WASHER
27	27	27	27	AN960JD416	WASHER
2*	2*	2*	2*	AN960JD416L	WASHER
4*	4*	4*	4*	AN960JD516	WASHER
3	3	3	3	AN960JD516	WASHER
2	2			AN960JD8	WASHER
4*	4*	4*	4*	AN970-4	WASHER

...CONTINUED ON NEXT PAGE

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Revision: G NO. 38843
Date: 08.03.04

...CONTINUED FROM PREVIOUS PAGE

Qty -043	Qty -044	Qty -045	Qty -046	Part Number	Description
2*	2*			MS20600AD4W3	RIVET
2*	2*	2*	2*	MS21042L3	NUT (OR MS21042-3)
4*	4*	5*	5*	MS21042L4	NUT (OR MS21042-4)
16	16	16	16	MS21042L4	NUT (OR MS21042-4)
4*	4*	4*	4*	MS21042L5	NUT (OR MS21042-5)
2	2	2	2	MS21042L5	NUT (OR MS21042-5)

* = ASSEMBLED AT DART

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

7.0 OPTIONAL EQUIPMENT

Qty -049	Part Number	Description
X	D205-541-049	LINER KIT
1	D2446	SIGN PLATE
1	D2509	LINER (BASE)
1	D2511	LINER (END)
6	MS24693S272	SCREW
6	A3235-020-935	WASHER
6	NAS679A3W	NUT
4	MS20470AD4-8	RIVET
42	MS20600AD4W4	RIVET

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